

Date: Friday, 01/08/2008 10:43:14 AM  
 User: Julie Lecocq

## Process Sheet

Rush

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	BRACKET ASSEMBLY
<b>Job Number</b> :	40906		
<b>Estimate Number</b> :	10420		
<b>P.O. Number</b> :		<b>Part Number</b> :	D3303043
<b>This Issue</b> :	01/08/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3303 REV. B
<b>First Issue</b> :	//	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	38969	<b>Drawing Revision</b> :	B
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	<u>JLD 08-8-05</u>	<b>Due Date</b> :	15/08/2008
<b>Comment</b> :	: Est: A 04.09.07 New Issue KJ/JLM		

Qty: 8/24 Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D33031	Plate
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✓  
**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 24.0000 Each(s)

PLATE

Pick:

Qty	Part Number	Description	Batch
1	D3303-1	Plate	<u>1338971</u>

SAP 08/08/07

2.0	D33033	Bracket
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✓  
**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 24.0000 Each(s)

BRACKET

Pick:

Qty	Part Number	Description	Batch
1	D3303-3	Bracket	<u>1338999</u>

SAP 08/08/07

3.0	MS20426AD33	Rivet
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✓  
**Comment:** Qty.: 8.0000 Each(s)/Unit Total : 192.0000 Each(s)

RIVET

Pick:

Qty	Part Number	Description	Batch
8	MS20426AD3-3	Rivet	<u>11563</u>

SAP 08/08/07

4.0	MS20470AD44	Rivet, Universal Head
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✓  
**Comment:** Qty.: 16.0000 Each(s)/Unit Total : 384.0000 Each(s)

Rivet, Universal Head

Pick:

Qty	Part Number	Description	Batch
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Next page -&gt;

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 01/08/2008 10:43:14 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 40906

Part Number: D3303043

Job Number:



Seq. #:

Machine Or Operation:

Description :

16 MS20470AD4-4 Rivet

M107823

SAD 08/08/08

(8)

5.0 MS21075L3

Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 96.0000 Each(s)

Nutplate

Pick:

Qty Part Number

Description

Batch

4 MS21075L3

Nut Plate

M108757

SAD 08/08/08

(8)

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg D3303

2- Identify as D3303-043

08/08/08

SAD 08/08/08

(8)

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 8/8/11 x8

8.0 POWDER COATING

POWDER COATING



M106442



(8X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

\*\*\*\*MASK THREADS PRIOR TO PAINT\*\*\*\*

START TIME:

8:15

OVEN TEMPERATURE:

320 OF

FINISH TIME:

8:45

M-1 08/08/12

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-08-12

(8)

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 188

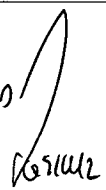


18 08/08/12

x6

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3303-043 PAR #: N/A Fault Category: Prod / FMS AS modification NCR: (Yes) No DQA: D Date: 08/08/12  
 QA: N/C Closed: D Date: 08/08/12

NCR: <u>40906</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/8/11	# 60	During inspection 3 assembly were found with 1 rivet installed incorrectly in each. R.C. Hummer error - moved		Drill out incorrect rivets AND replace MS20470AD4-4 Bk <u>107327</u> x 3	<u>SAY</u> <u>08/08/11</u>	<u>S</u> <u>8/8/11</u>		 <u>8/8/11</u>
		During Routing.						

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 10:43:14 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 40906

Part Number: D3303043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC21

FINAL INSPECTION/W/O RELEASE



2

Comment: FINAL INSPECTION/W/O RELEASE

22/08/08/12

Job Completion



h 08/08/12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

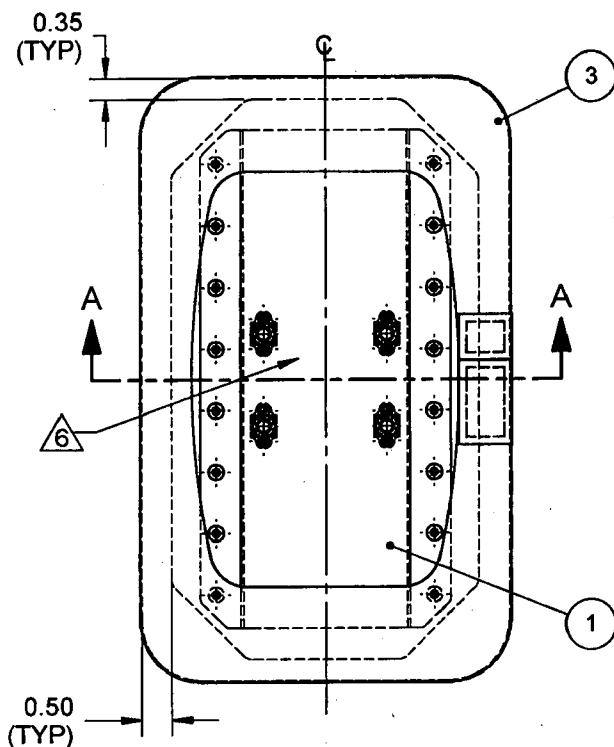
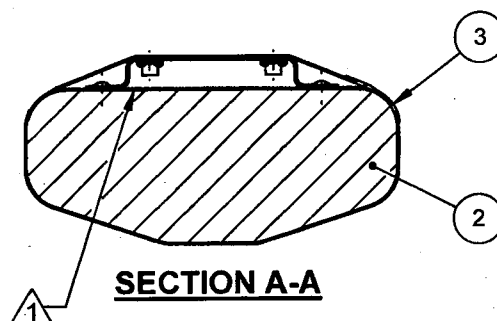
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3303</b>	REV. B SHEET 1 OF 4
DATE <b>06.08.17</b>	TITLE <b>HEAD REST</b>		SCALE 1:3
REV A	DATE 04.08.18	DESCRIPTION NEW ISSUE	
B	06.08.17	UPDATED FLAT PATTERN TO FORM PART IN ONE OPERATION USING OFFSET DIE	

**RELEASED***dc-09.19***D3303-041 HEAD REST**

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3303-041	HEAD REST
1	1	D3303-043	BRACKET ASSEMBLY
2	1	D3305-1	FOAM
3	1	D3306-041	COVER ASSEMBLY

**NOTES:**

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 COVER ASSEMBLY AS SHOWN
- 3) PART IS SYMMETRICAL AT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

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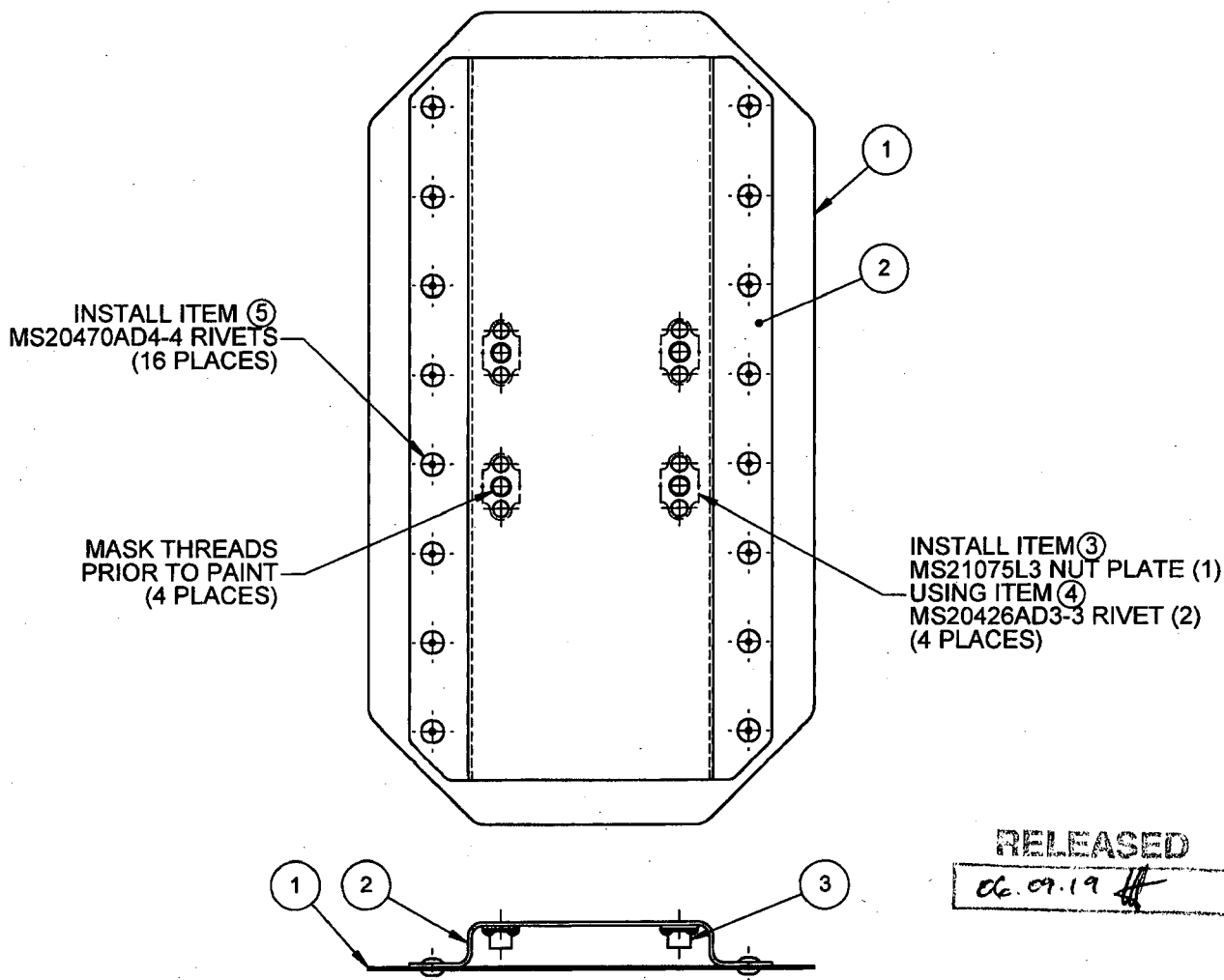
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DATE <b>06.08.17</b>		TITLE <b>HEAD REST</b>	SCALE 1:2

**D3303-043 BRACKET ASSEMBLY**

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3303-043	BRACKET ASSEMBLY
1	1	D3303-1	PLATE
2	1	D3303-3	HEAD REST
3	4	MS21075L3	NUT PLATE
4	8	MS20426AD3-3	RIVET
5	16	MS20470AD4-4	RIVET

**NOTES:**

- 1) FINISH: POWDER COAT ASSEMBLY GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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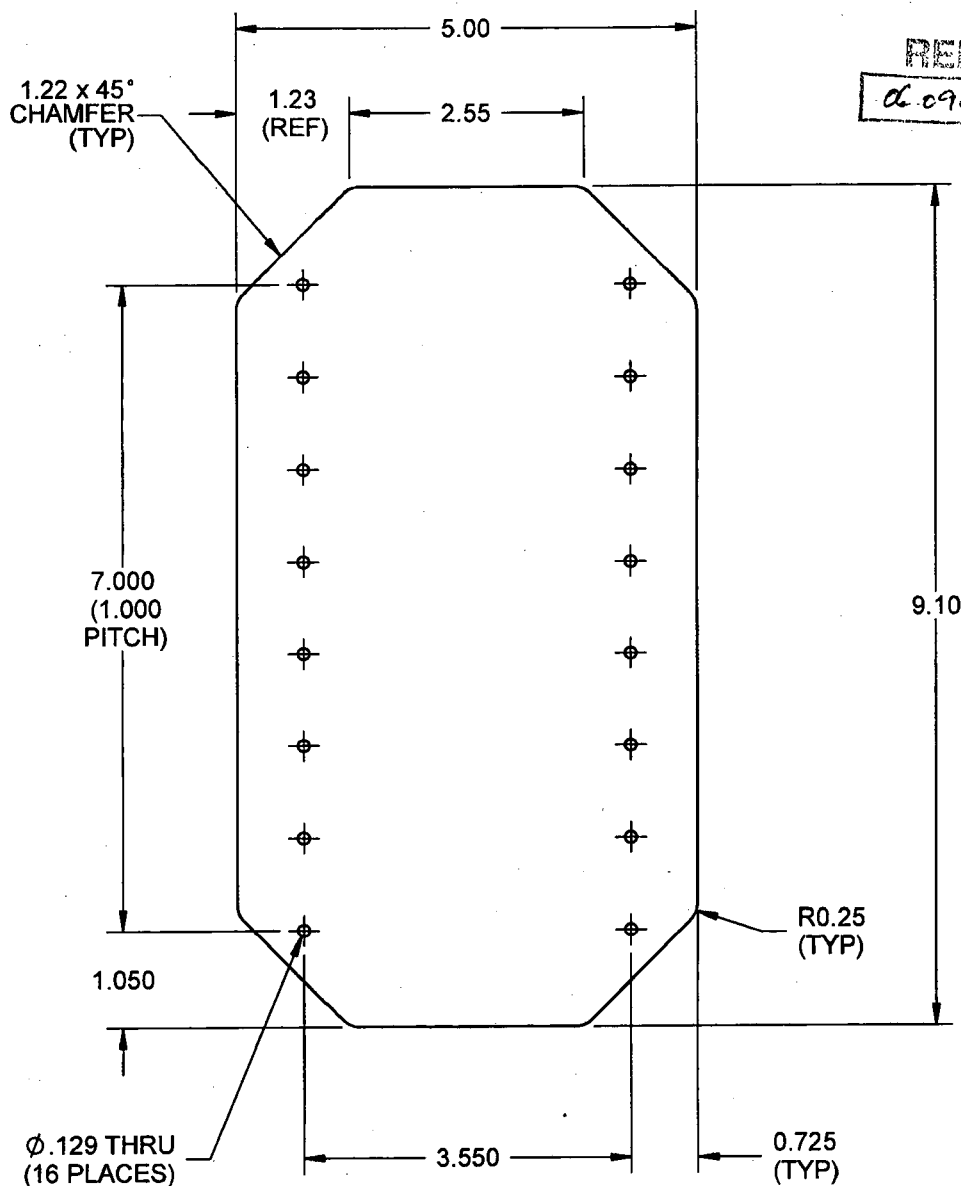
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DATE 06.08.17		TITLE HEAD REST	SCALE 1:2

**D3303-1 PLATE****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET (REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

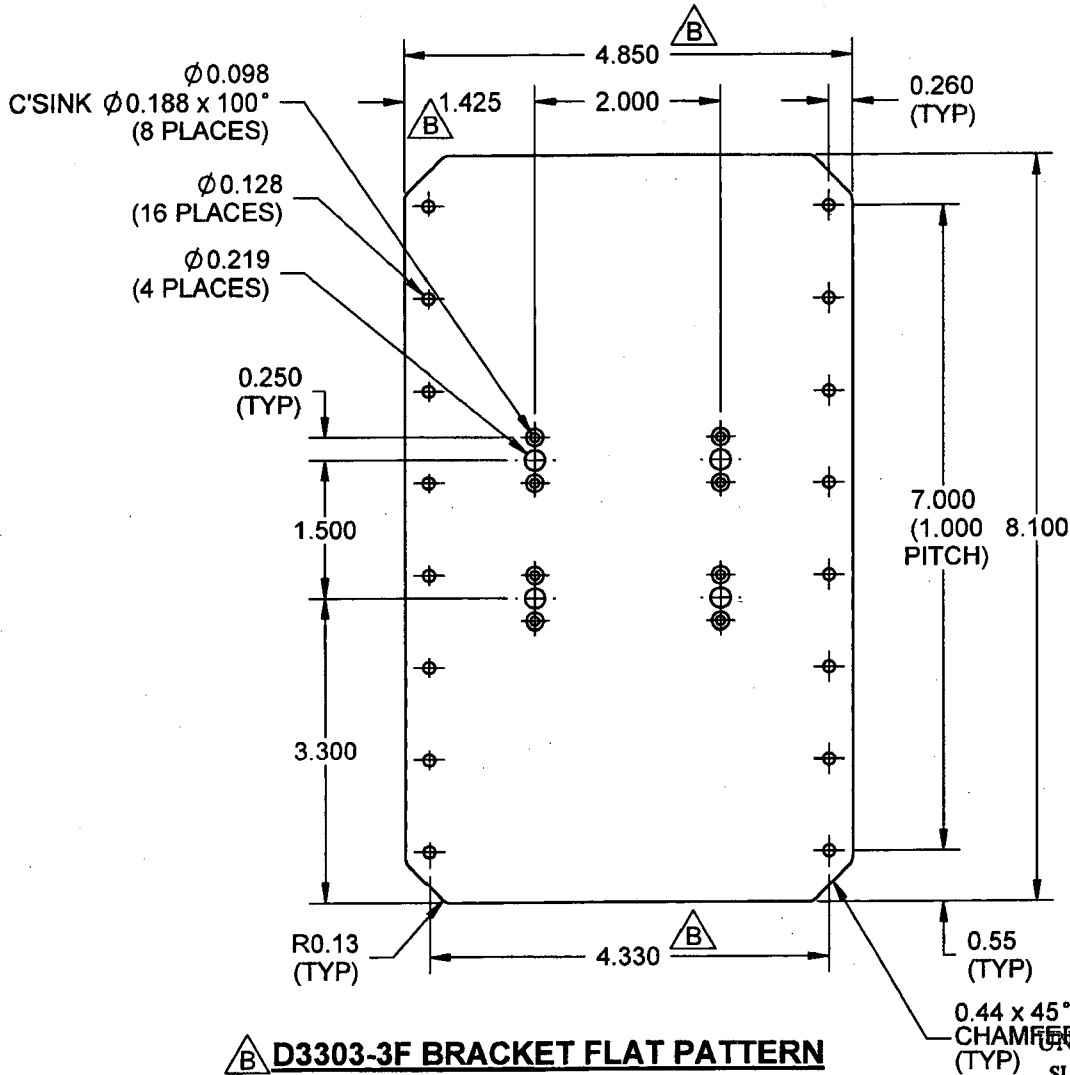
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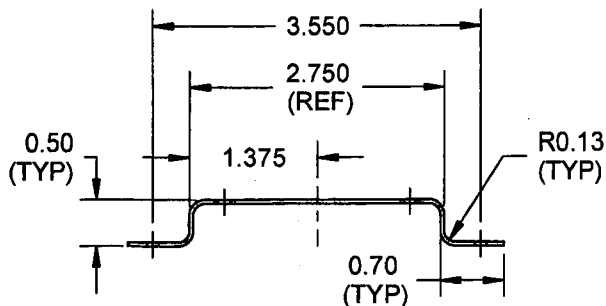
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DATE <b>06.08.17</b>	TITLE <b>HEAD REST</b>		SCALE 1:2



RELEASED  
06-09-19

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NO. 40906

**NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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